

Work Order ID 52174

Thursday, September 17, 2009 11:47:41 AM



Page 1

Item ID: D3936-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bottom

Start Date: 9/17/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

RL MK

Date:

9-9-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3936	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3936

Dwg Rev: *A*

Prog Rev: *A*

grain direction per dwg

2-Deburr if necessary,

B 9-9-17

(5)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-17

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Item ID: D3936-3

Accept

Revision ID: A

Item Name: Bottom

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 805/05/21

(x5)

/

130

Memo
Bend as per Dwg

0.00



Brake NC

Memo

0.00

Brake NC

80 09/10/05

5

/

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 805/05/05

(x5)

/

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Page 3

Item ID: D3936-3

Accept

Revision ID: A

Item Name: Bottom

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/10/06

x5



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

BR 09-10-06

⑤



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: G-A

0.00

SB 09/10/06

⑤



Packaging

Memo

0.00

Packaging

Work Order ID 52174

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Page 4

Item ID: D3936-3

Accept

Revision ID: A

Item Name: Bottom

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07
MF
09-10-06

Picklist Print

Thursday, September 17, 2009 11:47:40 AM

Page 1
T

Work Order ID: 52174



Parent Item: D3936-3RevA



Parent Item Name: Bottom



Start Date: 9/17/2009

Required Date: 9/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	134.5357	3.2884	4.1105		
												
6061-T6 .040 Sheet												

B 9-9-18

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	134.5357	
100742	3.3	
102723	7.93	
105842	12	
106747	12.5	
107461	13.1642	
109396	22.28	
111224	61.8615	
19380	1.5	

111224

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WITHOUT NOTICE

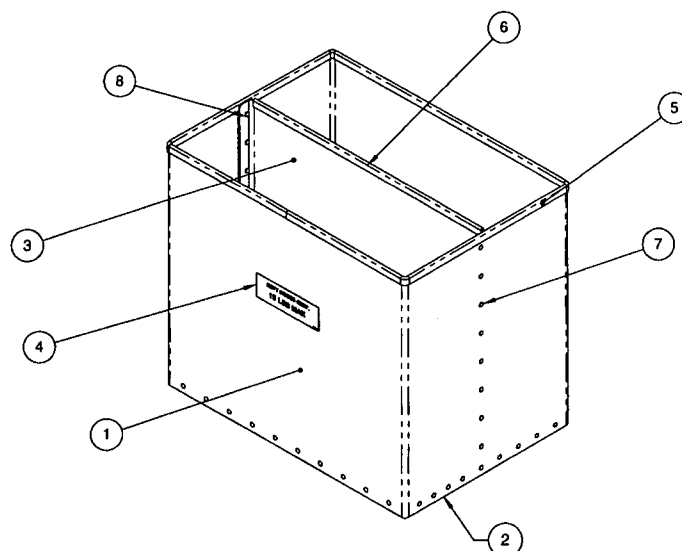
WORK ORDER

NO. 52179

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET

ASSEMBLY INSTRUCTIONS

- BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
- POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
- POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
- TRANSFER DRILL 10X $\phi 0.098$ (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
- TRANSFER DRILL 38X $\phi 0.098$ HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
- REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES $\phi 0.179 \times 100^\circ$. DEBURR ALL HOLES IN ALL PARTS.
- REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
- RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
- RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
- RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
- POWDER COAT ASSEMBLY PER NOTE 2.
- TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
- REMOVE RUBBER CUSHION.
- APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
- SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
- WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
- APPLY D3938-3 PLACARD AS SHOWN.
- ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.



D3936-041 MAPBOX ASSEMBLY

NOTES:

- MATERIAL: N/A
- FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- WEIGHT: 2.54 lbs

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2009-08-28
JMD

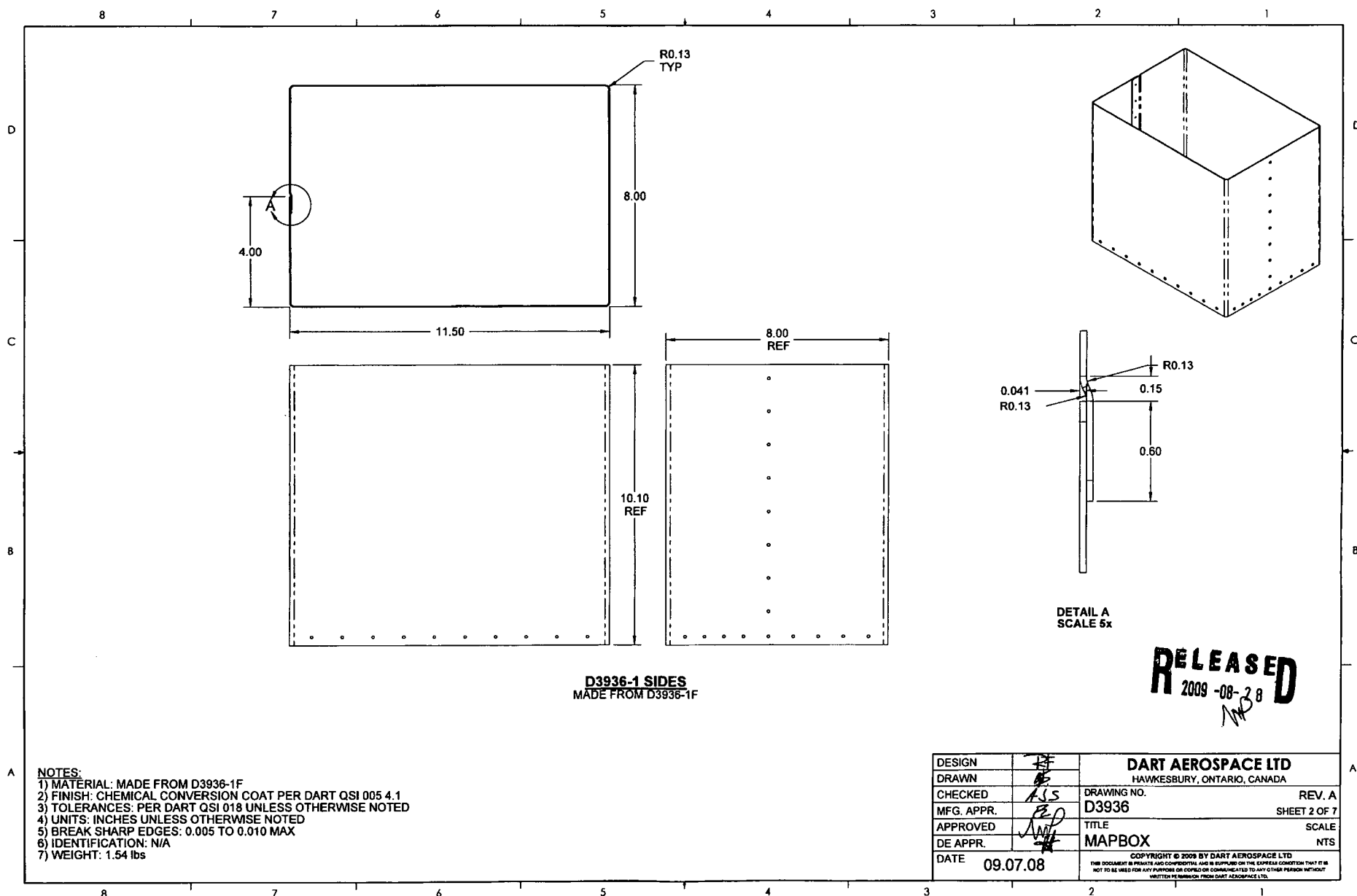
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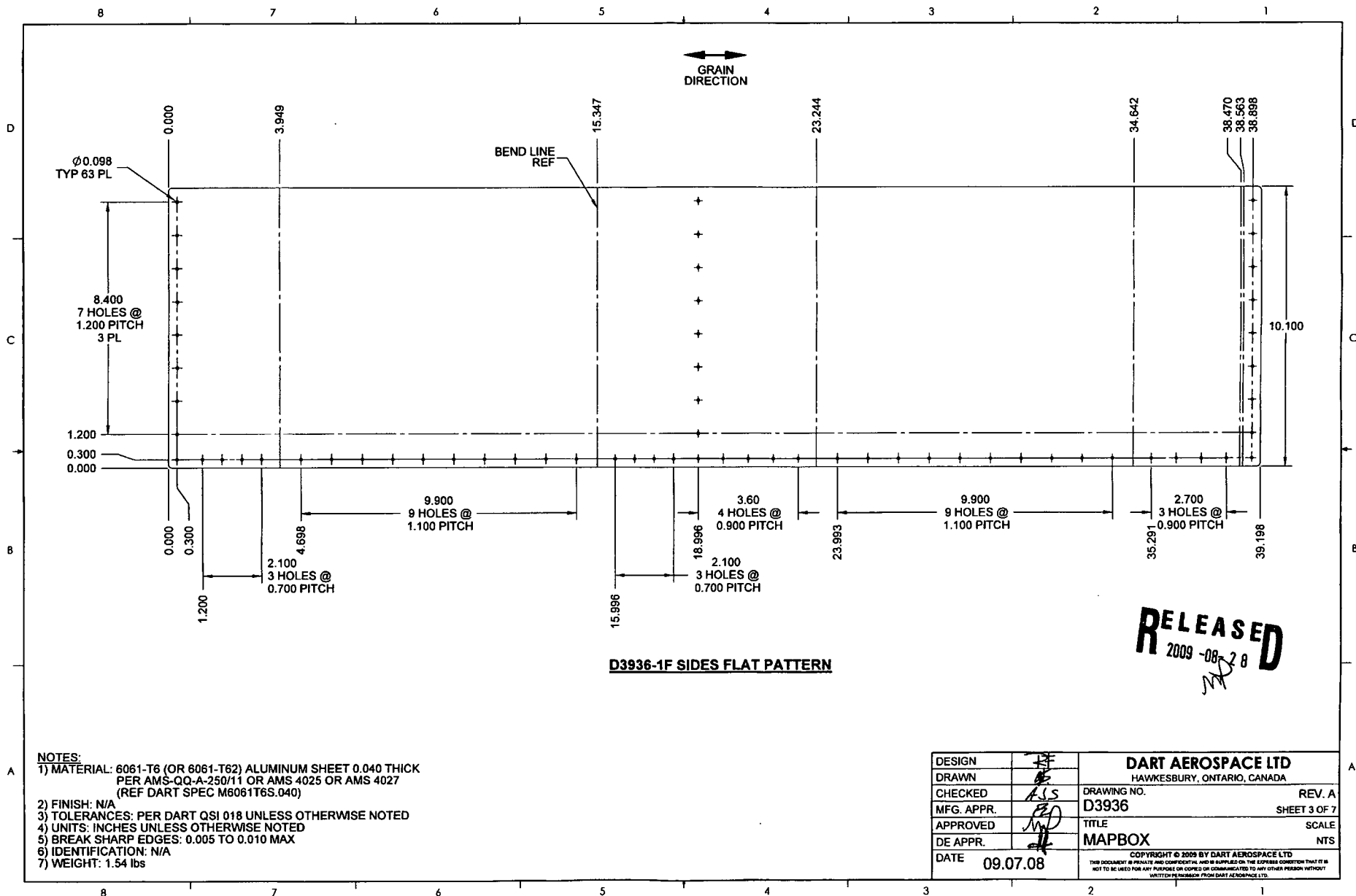
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REV. A
SHEET 1 OF 7
SCALE NTS

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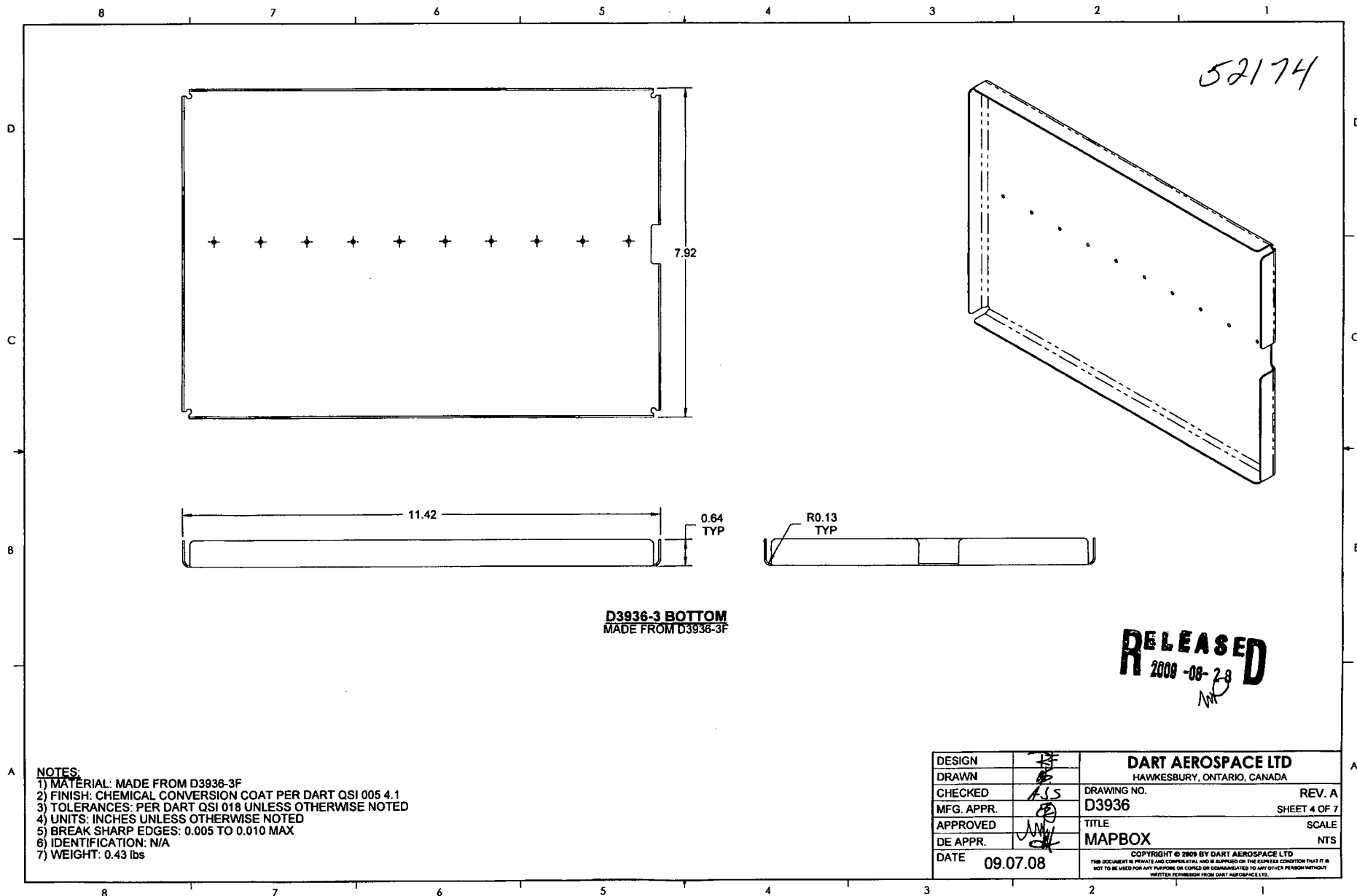


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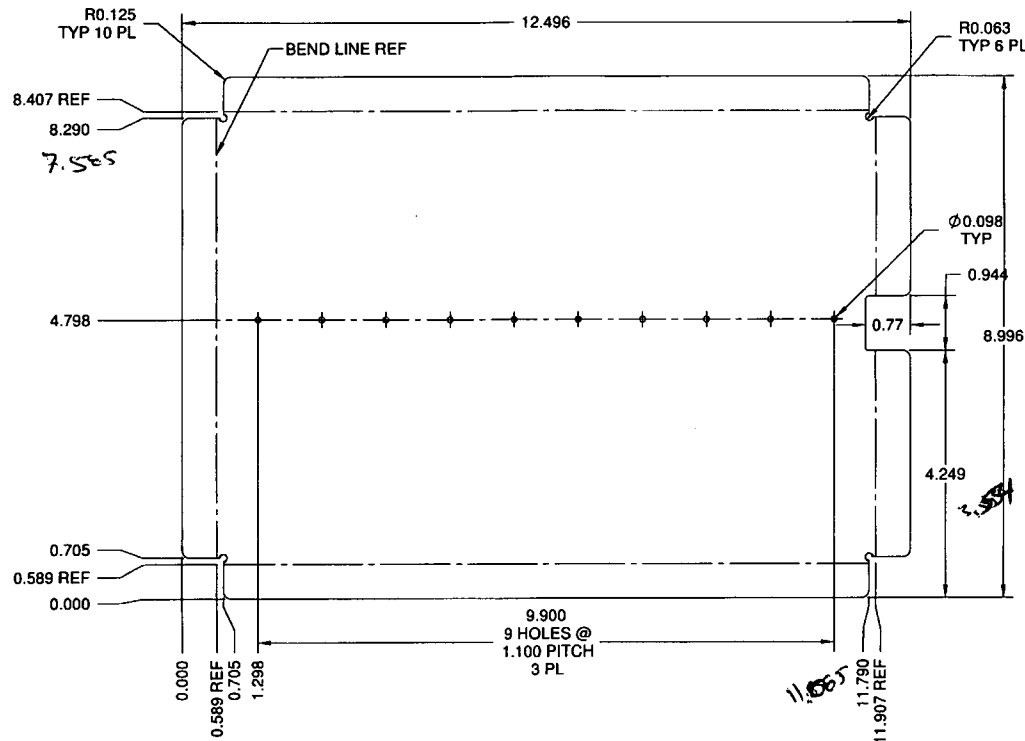
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.54 lbs

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CHECKED	ALS	DRAWING NO. D3936	REV. A
MFG. APPR.	ED	SHEET 3 OF 7	
APPROVED	MD	TITLE MAPBOX	SCALE
DE APPR.	MD	NTS	
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D3936-3F BOTTOM FLAT PATTERN

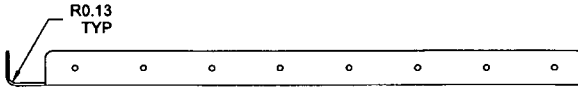
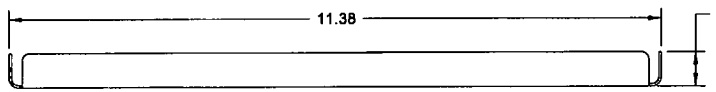
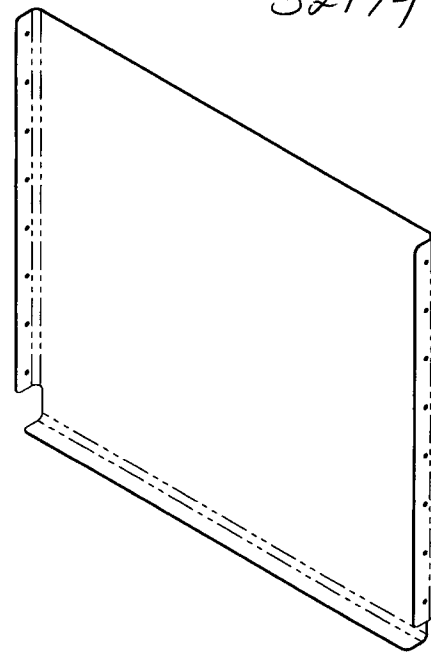
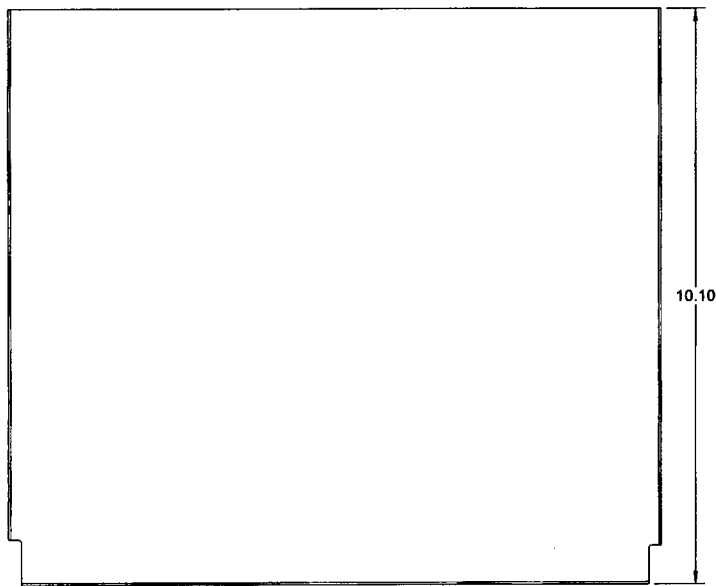
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

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52174



D3936-5 DIVIDER
MADE FROM D3936-5F

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2009-08-28

NOTES:

- 1) MATERIAL: MADE FROM D3936-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.50 lbs

DESIGN	1	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
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